

Date: Monday, 11/28/2005 10:24:46 AM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	ARM WELDMENT
Job Number :	24755		
Estimate Number :	10459		
P.O. Number :	N/A	Part Number :	D33791
This Issue :	11/28/2005	S.O. No. :	N/A
Prsht Rev. :	NC	Drawing Number :	D3379 REV C
First Issue :	N/A	Project Number :	N/A
Previous Run :		Drawing Revision :	C
Written By :	See Comment below	Material :	N/A
Checked & Approved By :	See Comment below	Due Date :	12/5/2005
Comment :	Est Rev:A 05.02.03 New-issue KJ/JLM	Qty:	5 Upr Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010B1000X02000	1010-1025 Steel Bar
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Comment: Qty.: 0.3281 f(s)/Unit Total 1.6406 f(s)
 Material: 1010-1025 Steel Bar
 (M1010-B1.000x02.000)
 Identify for D3379-1
 Batch: M 7731

SA 05.12.03

AOS
382

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW
 Cut blank: 2.00" x 1.00" x 3.750" long

SA 05.12.03

5+1

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA502 and Dwg D33792-
 2- Identify as D3379-1
 3-Deburr

SA 05.12.04 (5)

PTO
last pass

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 05.12.04 (5)

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SA 05.12.04 (5)

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Drawing Name: ARM WELDMENT

Job Number: 24755

Part Number: D33791

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 421

to 5/12/05

(5)

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

545 05/12/06

(5)

(5)

05/12/06

(5)

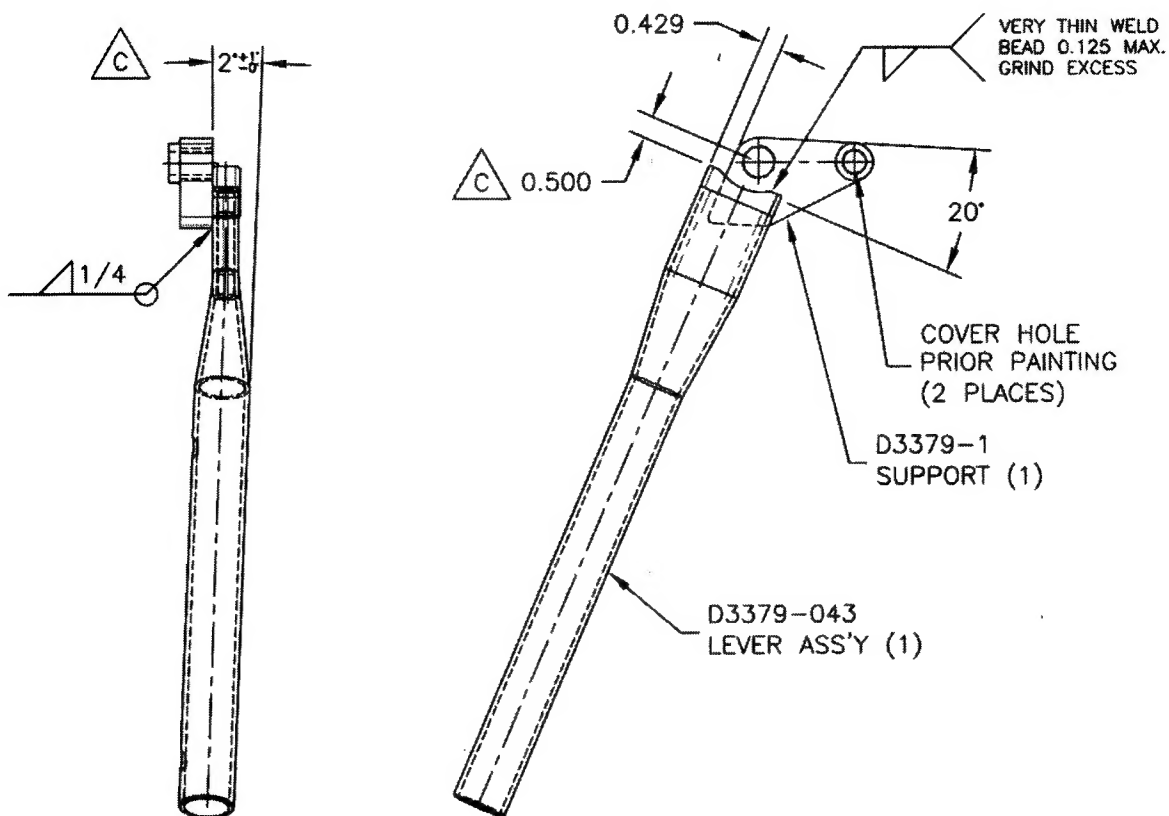
Job Completion



DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3379	REV. C SHEET 1 OF 4
DATE 05.05.27		TITLE ARM WELDMENT	SCALE 1:1
A	04.12.13	NEW ISSUE	
B	05.02.25	RE-DESIGN D3379-5	
C	05.05.27	2" WAS 4"; UPDATE DIMENSIONS	

RELEASED
05/04/05



D3379-041 ARM WELDMENT

NOTES:

- 1) POSITION PARTS AS PER JIG D3379-041T1
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT FIRE RED (REF 4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

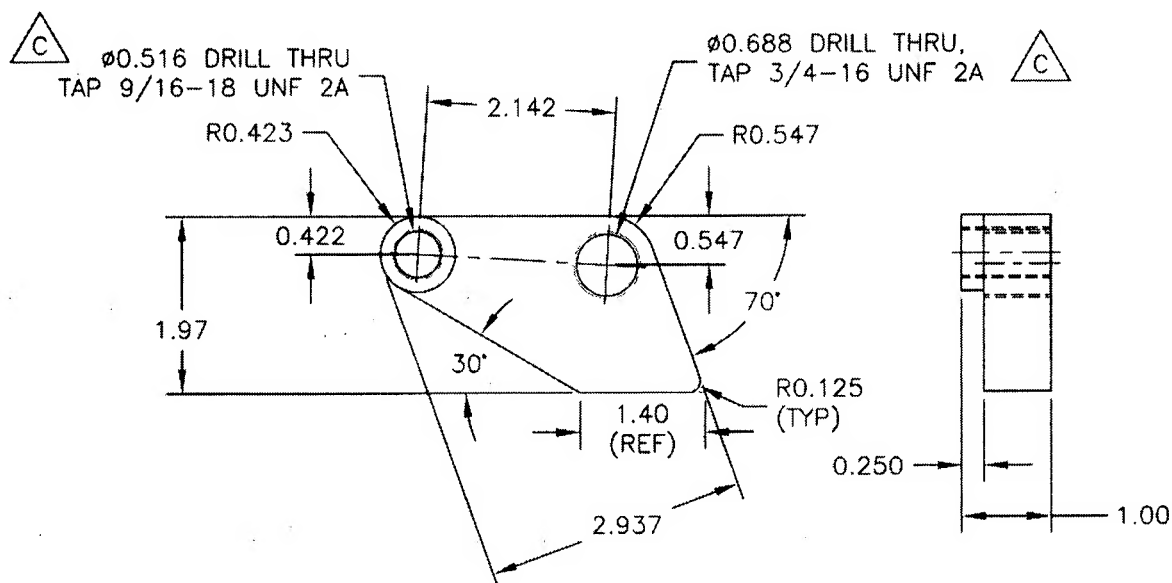
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DATE 05.05.27		TITLE ARM WELDMENT	SCALE 1:2

RELEASED
[Signature]
05/07/05



D3379-1 SUPPORT

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 1.000 STEEL (REF. DART SPEC. M1010-B1.000x02.000)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

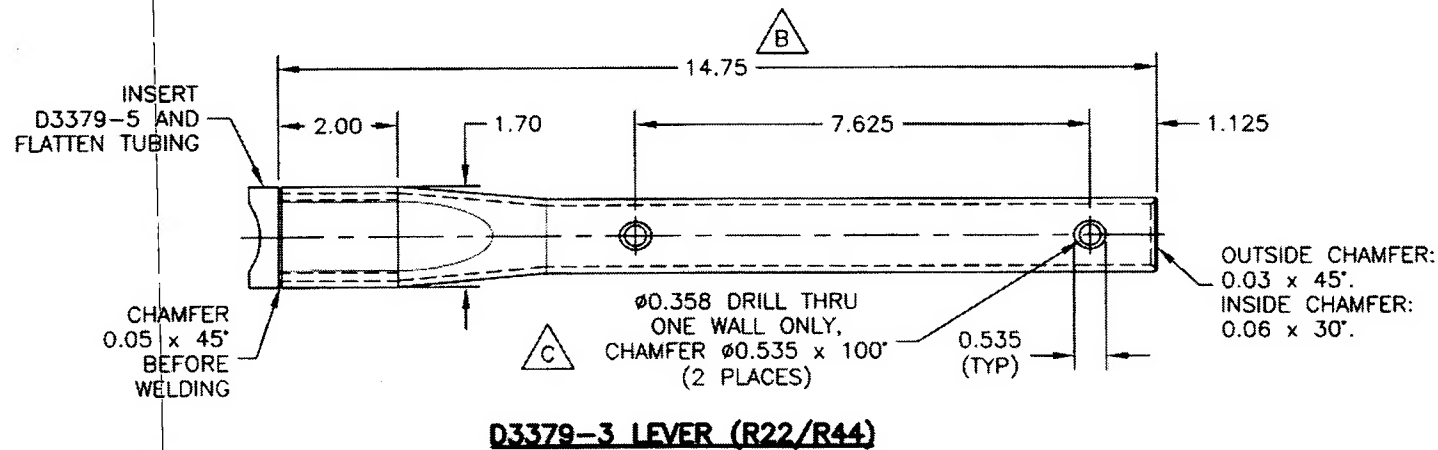
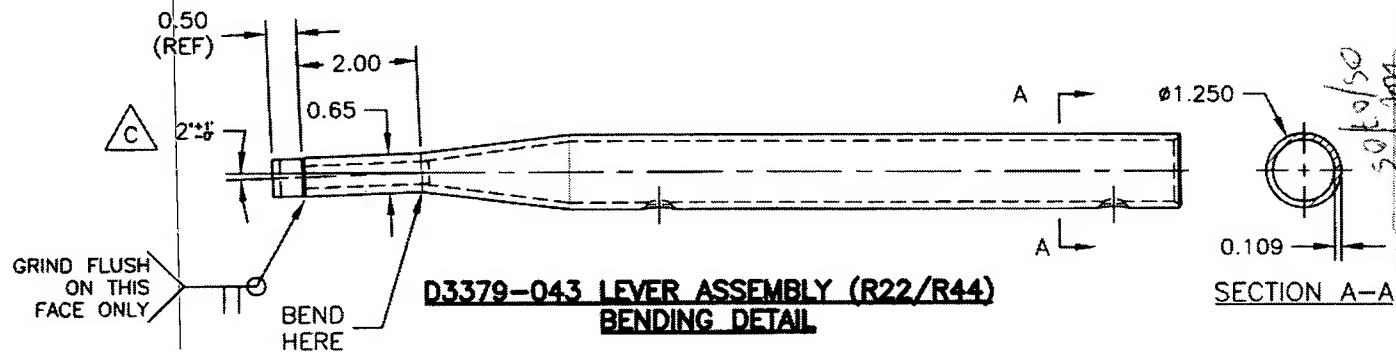
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DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAMKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. C
05.05.27	D3379	SHEET 3 OF 4
	TITLE	SCALE
	ARM WELDMENT	1:3

RELEASED
05/07/05



NOTES:

- 1) MATERIAL: 1018-1025 ROUND TUBING MILD STEEL SEAMLESS (REF. DART SPEC. M1018TR1.250W.109)
- 2) WELD PER QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

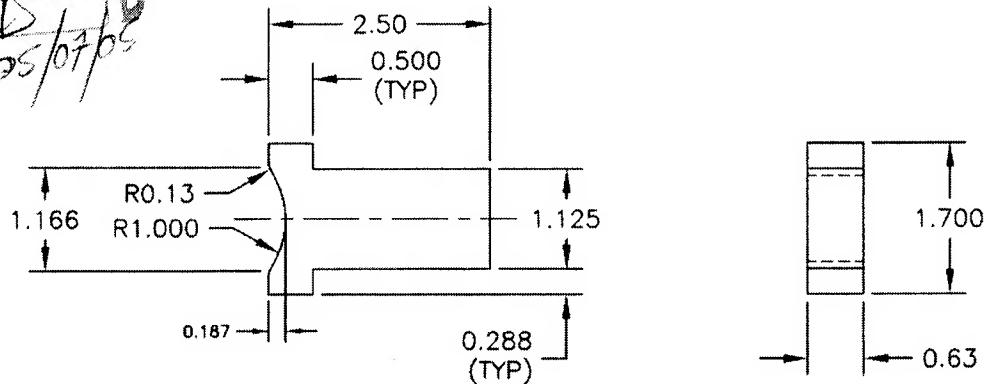
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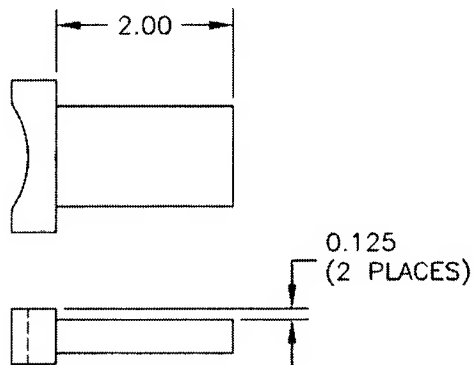
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DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3379	REV. C SHEET 4 OF 4
DATE 05.05.27	TITLE ARM WELDMENT		SCALE 1:1

RELEASED
[Signature]
05/07/05



D3379-5 LASER CUT PATTERN (R22/R44)



D3379-5 PLATE (R22/R44)

NOTES:


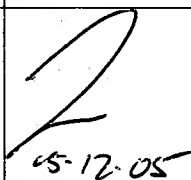

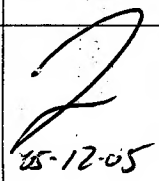
- 1) MATERIAL: 1010-1025 BAR MILD STEEL, 0.625 THICK
(REF. DART SPEC. M1010-B0.625)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 05/12/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
05.12.04	3	4.688 hole o/s (1 part) Drill was unavailable, An endmill was used and the first program edit cut part off.		Re-edit program. Destroy & Replace	BSG 05.12.04	 05-12-05		 05-12-05

NOTE: Date & initial all entries